

Description

Loxéal 3592 is a 2-components structural acrylic adhesive, curing by contact either drop on drop or bead on bead. Fixture time is reached in about 10 - 30 seconds. In 5 minutes the adhesive achieves more than 30% of its final strength. Suitable for bonding magnets and ferrites on electric motors, especially on high-speed production assembly lines. Adhesive provides assembled parts with highly tensile, impact and peeling resistance as well as excellent resistance to many chemicals. Non-corrosive formulation.

Physical properties

Part :	A	B
Composition :	urethane methacrylate	urethane methacrylate
Colour :	blu	yellow/green
Viscosity (+25°C - Pa s) :	10 - 20 thixo	3,5 - 5,5 thixo
Specific weight (g/ml) :	1.1	1.1
Shelf life :	1 year in original unopened packaging.	

Curing properties at +25°C (typical)

* Mixing ratio A+B:	1+1 no critical (weight/volume)	
* Handling time :	< 60	seconds
* Fixing time :	10 - 30	seconds
* Colour after mixing :	green	
* Gap filling :	min. 0,05 - max 1 mm (ideal 0.20 mm)	
* Full cure time :	24 hours	
* Shear strength: (ISO 4587) :		
• steel :	20 - 25	N/mm ²
• bolt :	15 - 20	N/mm ²
* Tensile strength (ISO 6922) :	25	N/mm ²
* Impact strength (ASTM D950) :	10 - 20	kJ/m ²
* Coefficient of Thermal Expansion : (ASTM D696)	80 x 10 ⁻⁶	1/K
* Thermal conductivity (ASTM C177) :	0,1	W/mK
* Temperature range :	-55°C / +165°C	

Directions for use

Clean and degrease surfaces to be bonded with Loxéal Cleaner 10. Apply part A to one surface and part B on the other. Alternatively, a bead on bead dispensing is possible; the adhesive is compatible with external mix equipments.

Join and press parts until adhesion is reached. Clean the excess of product with organic solvent. Wait for 24 hours to place parts under stressed conditions. For applications on different substrates from ones listed, please contact Loxéal Technical Department.

Storage

Keep product in a cool and dry room at a temperature from +5°C to +25°C. To avoid contaminations do not refill containers with used product. For further information on applications, storage and handling contact Loxéal Technical Service

Safety and handling

Consult Material Safety Data Sheet before use.

Note

The data contained herein, obtained in Loxéal laboratories, are given for information only; if specifics are required, please contact Loxéal Technical Department. Loxéal ensures abiding quality of supplied products according to its own specifics. Loxéal cannot assume responsibility for the results obtained by others which methods are not under Loxéal control. It is user's responsibility to determine suitability for user's purpose of any product mentioned herein. Loxéal disclaims all warranties expressed or implied, including warranties of merchantability or fitness for a particular purpose, arising from sale or use of Loxéal products. Loxéal specifically disclaims any liability for consequential or incidental damages of any kind, including lost profits.